



SKYscapes® Clearcoat Repair Reducer (Seam to Seam Repair) CM0850CR9

ADVANTAGES

- Designed for small stripes or quick repair on clearcoat over solid, metallic and mica finishes
- Ideal for repair from one edge to another.
- Quick drying
- No baking required
- Dries quickly at ambient temperatures
- Easy to mix

DESCRIPTION

SKYscapes® CM0850CR9 Clearcoat Repair Reducer has been developed to decrease the dry to tape times of the SKYscapes® Clearcoat for seam to seam clearcoat repairs. It is designed to be used on exterior surfaces of commercial and general aviation aircraft.

COATING PROPERTIES

Solids:	<u>Sprayable</u>
By weight	49.62%
By volume	42.71%
Density:	1.01
Viscosity—Sprayable	
Gardner Signature #2 Zahn Cup	14-18 seconds
Mixed V.O.C.	
U.S. Exempt Solvent	<3.5 lbs./gal (420 g/L)
Non-Exempt Solvent	<4.5 lbs./gal (535 g/L)
Useable Pot Life	
At 77°F / 25°C	3 Hours
Theoretical Coverage	
Per dry mil	685 ft. ² / gal.
Per 25 microns	16.8 m ² / L
Dry Film Weight	
Per dry mil	0.0061 lbs. / ft. ²
Per 25 microns	29.8 g / m ²

SHELF LIFE

Shelf life is applicable only for materials stored in unopened and undamaged original factory filled containers.

Minimum Storage Temp: 40°F / 4°C
Maximum Storage Temp: 100°F / 37°C

CM0850CR9: 7 Years



BLEND SUPPLY

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SURFACE PREPARATION

CM0850180 SKYscapes® Clearcoat is designed to be applied over Sherwin Williams 850 series SKYscapes® Basecoat colors. If overcoating window for SKYscapes® Basecoat has been exceeded, please apply CM0850AP5 or CM0850AP8 Adhesion Promoters prior to application of SKYscapes® Clearcoat.

MIXING INSTRUCTIONS

Mix by Volume:

- | | |
|---------------|--------------------------------------------------|
| 1 Part | SKYscapes® Clearcoat
CM0850180 |
| 1 Part | SKYscapes® Clearcoat Hardener
CM0850181 |
| 1 Part | SKYscapes® Clearcoat Repair Reducer
CM0850CR9 |

Add the Hardener and Reducer into the Clearcoat. Stir in slowly and allow a 15-30 minute induction time.

Typical use of this product is for small stripes or panel repairs on all aircraft sizes. Use when a extended wet edge is not required.

It is recommended to filter strain mixed Clearcoat before placing material in containers for spraying.

APPLICATION

Option 1 Apply one horizontal closed film coat followed immediately by a light vertical dust coat to ensure good flow and leveling.

Option 2 Apply one horizontal closed film coat, allow to flash off for approx ½ hour. Apply a second vertical closed film coat to ensure good flow and leveling.

Recommended dry film thickness: 1.6 mils to 2.2 mils

RECOMMENDED FLUID TIP SIZES

Electrostatic Airspray with pressure pot

Fluid Tips 1.0 to 1.4mm
Air Cap Pressure 45 psi – 100 psi

HVLP / compliant guns.

Fluid Tips 1.2 - 1.4mm
Air Cap Pressure 10 psi – 30 psi

DRYING SCHEDULE

Dry times are based on the dry film thickness of 2 mils (50 microns).

Air Dry Times (75°F / 25°C and 50% RH)	Min.
Dry to Tape	2-3 Hours
To lightly sand re-apply or buff clearcoat	
Force Dry: (max 120°F (45°C), 45% RH)	
Flash Off Time	1 Hour
Force Heat Time	30 minutes

NOTE: Lower temperatures, heavy film thickness, improper and poor air movement will extend the dry time.

PREPARING CLEARCOAT FOR REAPPLICATION

Use one of the following options when it is necessary to re-apply clearcoat for repairs or additional coats:

- Use 320-grit D/A papers or higher (preferred).
- Fine grade Wet/dry sandpaper (600+) may also be used
- Red or Gray scotchbrite

CLEARCOAT PREPARATION PRIOR TO OVERCOATING

Use SW Aerospace CM0110120 Pre-paint Wipe Cleaning solvent to remove dust or light contamination. Use the wipe on, wipe off technique. Change to clean cloths regularly. Allow CM0110120 to flash off for a minimum of 15 minutes before re-applying Clearcoat.

To reactivate aged basecoat or to remove finger marks and tape gum, apply SKYscapes® Adhesion Promoter (**CM0850AP8**) prior to applying clearcoat

Refer to the **CM0850AP8** Product Data sheet for additional information.

EQUIPMENT CLEANUP

Use clean Ketone-type solvents such as CM0110308. Do not allow material to cure inside equipment.




PRODUCT INFORMATION

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application, which are not known, or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.



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- 1** Mix by volume.
- 2** Add in order shown below. The Hardener and Reducer should be mixed into the clear component. Stir as components are added.

Order of Addition	Volume	U.S.		Metric	
		Large	Small	Large	Small
 CM0850180 Clearcoat	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0850181 Clearcoat Hardener	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L
 CM0850CR9 Clearcoat Repair Reducer	1 Part	1 Gal.	1 Qt.	3.8 L	.95 L

- 3** Allow mix to induct 15-30 minutes.
- 4** Typical use of this product is for small stripes or panel repairs (seam-to-seam) on all aircraft sizes. Use when an extended wet edge is not required.
- 5** Filter strain and apply.

